

Date: Friday, 17/08/2007 11:14:54 AM
 User: Linda Lacelle

Process Sheet

B L J R

37

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID
 Job Number : 34057
 Estimate Number : 10525
 P.O. Number : N/A Part Number : D206642411 B L
 This Issue : 17/08/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 34056 Material : N/A
 Due Date : 12/09/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 17.08.20
 Comment : Est Rev:K 95.10.11 Revised picklist per CHG004 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

2.0 34057A 206 L HIGH GEAR SKIDTUBE



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B 34057A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2652 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 D2652 Bushing B34074

1 D206-642-441(REF) B34057A

5.0 D2655 Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2655 Tow Ring B34145

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 34057

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2659 Lug Assembly

B 34433

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

B 33667

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-1

Saddle

B 34155

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-1

Saddle

B 38742

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

B 33235

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

B 33219

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 34057

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 D2938-1

Description Batch

Saddle

B34156

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 D2939-1

Description Batch

Saddle

B34157

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

1 D2968-043

Description Batch

Tow Ring

B34151

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

4 AN3-37A

Description Batch

Bolt

M102339

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

8 AN3-41A

Description Batch

Bolt

M104625

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 34057

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M100857

CU

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M100057

CU

19.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M104746

CU

20.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt

M104746

M104156

CU

21.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-13A

Bolt

M15928

CU

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 34057

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN960JD10

Washer

M104885

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN960JD1016

Washer

M8519

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description Batch

25 AN960JD416

Washer

M104746

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 AN960JD516

Washer

M104156

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN970-4

Washer

M104885

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Qty Part Number

Description Batch

12 MS21042L3

Nut (or -3)

M104936

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/08/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34057

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4) M104248

LO 7/8/13 (1)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10A-05-14 (1) Blue

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location: D

PPP Rev: D

LU 7/9/14

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10A-05-14 (1) 07/09/14

Job Completion



LU 07-09-14

B34057A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:14:54 AM
User: Linda Lacelle

Process Sheet

37

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID
Job Number : 34057
Estimate Number : 10525
P.O. Number : Part Number : D206642411
This Issue : 17/08/2007 S.O. No. : Drawing Number : N/A
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : LANDING GEAR Drawing Revision : N/A
Previous Run : 34056 Material :
Written By : Due Date : 12/09/2007 Qty: 1 Um: Each
Checked & Approved By : 07.08.20
Comment : Est Rev:K 95.10.11 Revised picklist per CHG004 KJ/CP/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

07.08.20

2.0	34057A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------

Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE
D206-642-441 B

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	D2652	Bushing
-----	-------	---------

Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
24 D2652 Bushing
1 D206-642-441(REF)

REFERENCE ONLY

5.0	D2655	Ring
-----	-------	------

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D2655 Tow Ring

Date: Friday, 17/08/2007 11:15:24 AM
User: Linda Lacelle

Process Sheet

37

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 34057A
Estimate Number : 10522
P.O. Number : N/A Part Number : D206642441
This Issue : 17/08/2007 S.O. No. : N/A Drawing Number : D2650 REV E
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : E
Previous Run : 34056A Material : N/A
Written By : Due Date : 12/09/2007 Qty: 1 Um: Each
Checked & Approved By : 07.08.20
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A 07.08.20

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B33879

pm 07-08-21

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B29328 BE 07-08-22

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube pm 07-08-21

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 pm 07-08-21

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m104221/m105058 BE 07-08-22

4-Grind weld flush to cap on top surface only. BE 07-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

AWM
07/08/24

DP 7-8-27

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM
07/08/27

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B 34/69

AWM
07/09/04

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 07/09/04

Time: 11:40AM

Finish Date: 07/09/05

Time: 8:00AM

A/R Sikaflex-291

17105469

Sikaflex expiry date:

08/01/07

AWM
07/09/04

AWM
07/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



on 7/10/05



Comment: INSPECT WORK TO CURRENT STEP

Pin all 191 through all holes

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B-33214

BE

07-09-05

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M 104221 BE 07-09-05

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

DP 7-9-5

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

B30446

DP 7-9-5

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

103525

DP 7-9-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

102515

DP 7-9-5

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP 7-9-5

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/05

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/06

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

07/09/06

(1)

18.0

~~POWDER COATING~~

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

Issue P.O. 4543
- clear blue
- clear blue

07/09/07

19.0

QC14

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/09/12

(1)

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

332465

07/09/12

(1X)

186 Receive & Inspect 07/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

21.0	D265615	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe

B 34170

M. A

22.0	D265623	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-23 Wearshoe

B 32580

M. A

23.0	D265637	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-37 Wearshoe

B 32017

M. A

24.0	D34291	
------	--------	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3429-1 Wearpad

B 32510

M. A

25.0	ALS41032130	Insert
------	-------------	--------



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number Description Batch
60 ALS4-1032-130 Inserts
or (see QSI 017)

M 102475

M. A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



*

Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104885

M-L

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

M104603

M-L

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

B34146
~~B33185~~

M-L

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B32099

M-L

30.0

AN960JD416

Washer



(1X)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M103338

M-L 07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	MS27039406	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 MS27039-4-06 Screw

M15194

M.L

32.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap

B34152

M.L

33.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 AN960JD10L Washer

M104885

M.L *

34.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS27039-1-08 Screw

M104603

M.L

35.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

M105469

08-01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

M.L 07/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 01/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:15:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34057A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M105487
08-01

m-h 07/09/12

(1X)

6-Wing Walk as per Dwg D2650-7 and QSI 005 4:4

Batch: M105386

ml 070912

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/12

37.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/12

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

RRP 34057 07/09/13

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)
Donor 07/09/14

Job Completion



W 07/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>19</i>	DRAWN BY <i>19</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
06 04 17 *[Signature]*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH:
-CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34057A*

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

1-10

NO. 125

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barclay E.

Joint Welding Procedure Tig

Part number and Job number ~~0058672041/83337 A~~

Also good for A206 Same / cross bolt spacer

TEST WELDS REQUIRED

BASE METAL Alum

WELDING PROCESS Tig

Penetration Complete ☐ Partial ☒

Single Weld ☒ Double Weld ☐

Current AC ☒ DC ☐

Backing YES ☐ NO ☒

Position

Vertical Down ☐ Up ☐

Sheet Groove

1G ☐

2G ☐

3G ☐

4G ☐

Tube Groove

1G ☐

2G ☐

5G ☐

6G ☐

Sheet Fillet

1F ☐

2F ☐

3F ☐

4F ☐

Tube Fillet

1F ☐

2F ☐

4F ☐

5F ☐

Crossbolt Spacer Welded into

Skidtube

TEST RESULTS

Visual

Pass ☒ Fail ☐

Penetration

Pass ☒ Fail ☐

Crossbolt Spacer

Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon

07/09/05

Qualifier

David Sewal